

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 11/03/09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3507

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

8/16/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 2

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

0.00

1-Cut Aft end as per dwg D3507

2-Deburr ends

3-Drill Aft & Fwd Cap holes using DT8678 & DT8901

4-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES*****

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open holes to 0.297"

9-Open Aft & Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 & Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Deburr holes.

1 0 BEN/03/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM

Page 3

Item ID: D135-751-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Suloh11

FD

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1

B11/02/11

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-3-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM

Page 4

Item ID: D135-751-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex

Batch:

Exp Date:

start time:

end time:

5-Weld x-bolt (D3504-1/-3)spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD

Batch:

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

BB 11/03/16.

BE 11/03/17

7 BE 11/03/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM

Page 5

Item ID: D135-751-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 6

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 BL 11-3-18

220



Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 BL 11-3-18

230



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

1 d 11-3-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 7

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 	HandFinishing	0.00							
HandFinish	Memo	0.00							
Hand Finishing	✓ Install Wearplate & Ground Wire inserts as per Dwg D3507.								
250 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	Inspect Inserts								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM

Page 8

Item ID: D135-751-011

Accept

Revision ID:

Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:



Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260  HandFinish Hand Finishing	HandFinishing Memo 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" A/R 241 Sika Flex Batch: <u>1116040</u> Exp Date: <u>4/09</u> 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Screws where indicated on Dwg(Note #6) A/R 241 Sika Flex Batch: <u>1116040</u> Exp Date: <u>4/09</u> 4-Install Plug assemblys with lubricate as per Dwg D3507. Batch: <u>1114189</u> 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: <u>1116402</u>	0.00 0.00							<u>1 d M 4/03/12</u>
270  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>8 4/09/12</u>

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 9

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 Packaging Packaging	Pick Kit Memo	0.00 0.00							
290 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
300 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D135-751-011 Location: _____ PPP Rev: <u>B</u>	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67130

Wednesday, March 09, 2011 9:50:41 AM



Page 10

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 3/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22

MF
11-03-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:37 AM

Page 1

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation




Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM
 IPP Rev:B 06-12-18 As per Rev B JLM
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3507-1-BENT  Skidtube Assembly EC135		Manufactured	No			120	Each	2.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>2</div> <div></div> </div>													
<div> <div>62291</div> <div>1</div> <div></div> </div>													
<div> <div>62292</div> <div>1</div> <div></div> </div>													
D3504-1  Crossbolt Spacer		Manufactured	No			170	Each	18.0000	2	2			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>18</div> <div></div> </div>													
<div> <div>53742</div> <div>18</div> <div></div> </div>													
D3504-3  Crossbolt Spacer		Manufactured	No			170	Each	30.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>30</div> <div></div> </div>													
<div> <div>31232</div> <div>10</div> <div></div> </div>													
<div> <div>53743</div> <div>20</div> <div></div> </div>													

BE 11/05/11
 67132

BE 11/03/17

BE 11/03/17

1-2

LF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:37 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-5
Crossbolt Spacer

Manufactured No

170 Each 18.0000 2 2

Location	Loc Qty	Loc Code
LG	18	
36181	2	
53744	16	

D3505-1
Web

Manufactured No

170 Each 0.0000 1

B 67133

D3506-1
Doubler

Manufactured No

190 Each 70.0000 4 4

Location	Loc Qty	Loc Code
ST063	70	
51789	70	

D3506-3
Doubler

Manufactured No

190 Each 66.0000 2 2

Location	Loc Qty	Loc Code
ST063	66	
51790	66	

MS20601-AD4W3

Purchased No

190 Each 3,523.000 12 12

Rivet

Location	Loc Qty	Loc Code
ST321	3523	
114538	3523	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Wednesday, March 09, 2011 9:50:37 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

ALS7-1032-130 Purchased No

240 Each

1,538.000 38 38



Insert

Location

Loc Qty

Loc Code

FP

21

115079

21

ST282

1517

113238

17

115502

500

116800

1000

HL 11/03/22

ALS4-1032-225 Purchased No

260 Each

3,809.000 1 1



Insert

Location

Loc Qty

Loc Code

PK011

3809

110768

3809

K 38
HL 11/03/22

AN3C4A Purchased No

260 Each

2,161.000 31 31



BOLT

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

X1
HL 11/03/22

Y3t

Wednesday, March 09, 2011 9:50:37 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:37 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

260

Each

1,008.000

2

2



Bolt



HL 11/03/22

Location

Loc Qty

Loc Code

ST350

1008

107862

68

108302

34

114330

11

115015

13

115371

4

115422

100

115835

178

116419

500

116549

100

VZ

AN526C1032R10

Purchased

No

260

Each

390.0000

2

2



Screw



HL 11/03/22

Location

Loc Qty

Loc Code

ST327

100

114494

100

ST328

290

108062

126

110049

164

VZ

AN960C10L

NAS1149C0332

Purchased

No

260

Each

61.0000

33

33



washer



HL 11/03/22

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

1116304

V33

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:37 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

35.0000

1

1



Cap, 105 Skidtube



JH 11/03/22

Location

Loc Qty

Loc Code

FP4

35

52057

35

Y1

D2965-3

Manufactured No

260

Each

7.0000

1

1



Cap



JH 11/03/22

Location

Loc Qty

Loc Code

FP

7

B46582

X1

50560

3

52282

4

D3492-041

Manufactured No

260

Each

77.0000

4

4



Plug Assembly



JH 11/03/22

Location

Loc Qty

Loc Code

FP013

77

59114

1

62210

3

63994

29

65068

44

X4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:38 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-043

Manufactured No

260

Each

125.0000

4

4



Plug Assembly



HL 11/03/22

Location

Loc Qty

Loc Code

FP

2

54682

2

FP013

123

59117

1

59190

4

63996

2

65070

16

66150

20

66931

80

x4

D3492-047

Manufactured No

260

Each

37.0000

2

2



Plug Assembly



HL 11/03/22

Location

Loc Qty

Loc Code

FP

37

28961

26

39722

11

x2

D3508-1

Manufactured No

260

Each

19.0000

1

1



Wearplate



HL 11/03/22

Location

Loc Qty

Loc Code

FP

5

42973

1

51261

4

FP-16

14

61020

14

x1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:38 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-3

Manufactured No

260

Each

8.0000

1

1



Wearplate



HL 11/03/22

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

7

62882

1

65192

6

D3508-5

Manufactured No

260

Each

5.0000

1

1



Wearplate



HL 11/03/22

Location

Loc Qty

Loc Code

FP

1

42251

1

FP21

4

51388

4

D3508-7

Manufactured No

260

Each

3.0000

1

1



Wearplate



HL 11/03/22

Location

Loc Qty

Loc Code

FP

1

31198

1

FP21

2

60336

2

B67159

XL

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:38 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-1
Gasket

Manufactured No 260 Each 16.0000 1 1


 HL 11/03/22

Location	Loc Qty	Loc Code
FP	16	
42533	1	
50925	15	

VI

D3558-3
Gasket

Manufactured No 260 Each 6.0000 1 1


 HL 11/03/22

Location	Loc Qty	Loc Code
FP	6	
42253	1	
55468	5	

VI

D3558-5
Gasket

Manufactured No 260 Each 6.0000 1 1


 HL 11/03/22

Location	Loc Qty	Loc Code
FP	6	
43244	1	
50926	5	

VI

D3558-7
Gasket

Manufactured No 260 Each 3.0000 1 1

 HL 11/03/22

Location	Loc Qty	Loc Code
FP	3	
43245	1	
50927	2	

VI

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 9:50:38 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007

Purchased

No

260

Each

440.0000

2

2



O-RING



Handwritten: 4/03/22

Location

Loc Qty

Loc Code

FP

440

103697

440

x2

NAS1611-010

Purchased

No

260

Each

309.0000

4

4



O-RING



Handwritten: 4/03/27

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

x4

115589

50

NAS1611-013

Purchased

No

260

Each

243.0000

4

4



O-RING



Handwritten: 4/03/22

Location

Loc Qty

Loc Code

FP

243

115460

100

115589

28

115812

20

116582

95

x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 10

Wednesday, March 09, 2011 9:50:38 AM

Work Order ID: 67130

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 3/23/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

2,161.000

8

8



BOLT

Location

Loc Qty

Loc Code

ST350

2161

115300

25

116075

337

116704

114

116924

1200

117010

485

116825

AN960C10L

NAS1149C0332

Purchased

No

280

Each

61.0000

8

8



washer

Location

Loc Qty

Loc Code

ST245

61

107534

59

108246

2

D3512-1

Manufactured

No

280

Each

1.0000

2

2



Wearplate

Location

Loc Qty

Loc Code

ST500

1

63954

1

67164

11/3/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action . Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

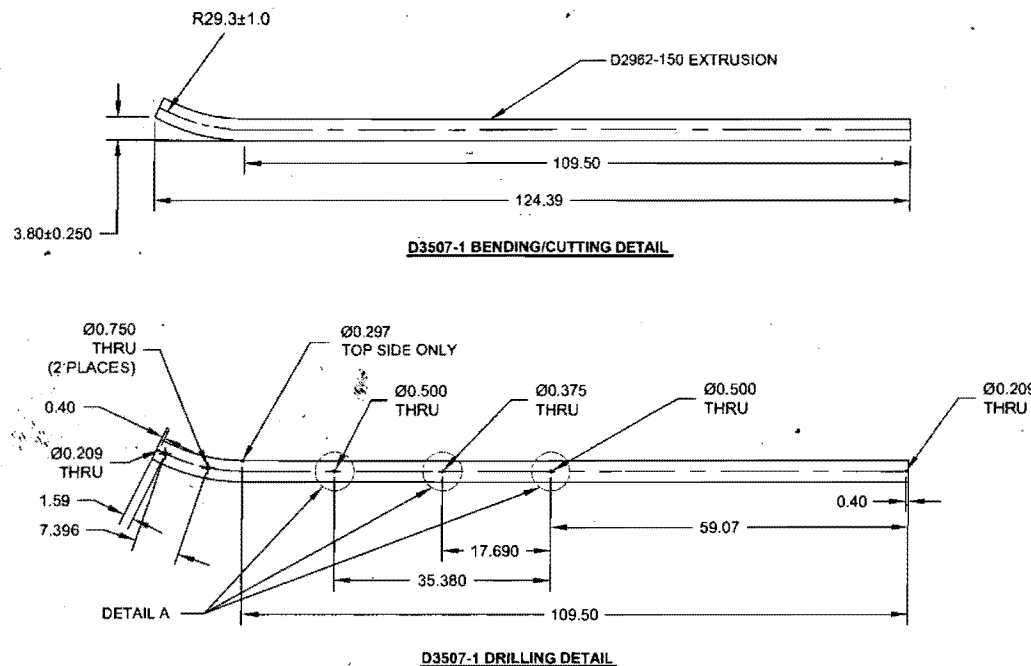
NOTE: Date & initial all entries

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING.
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

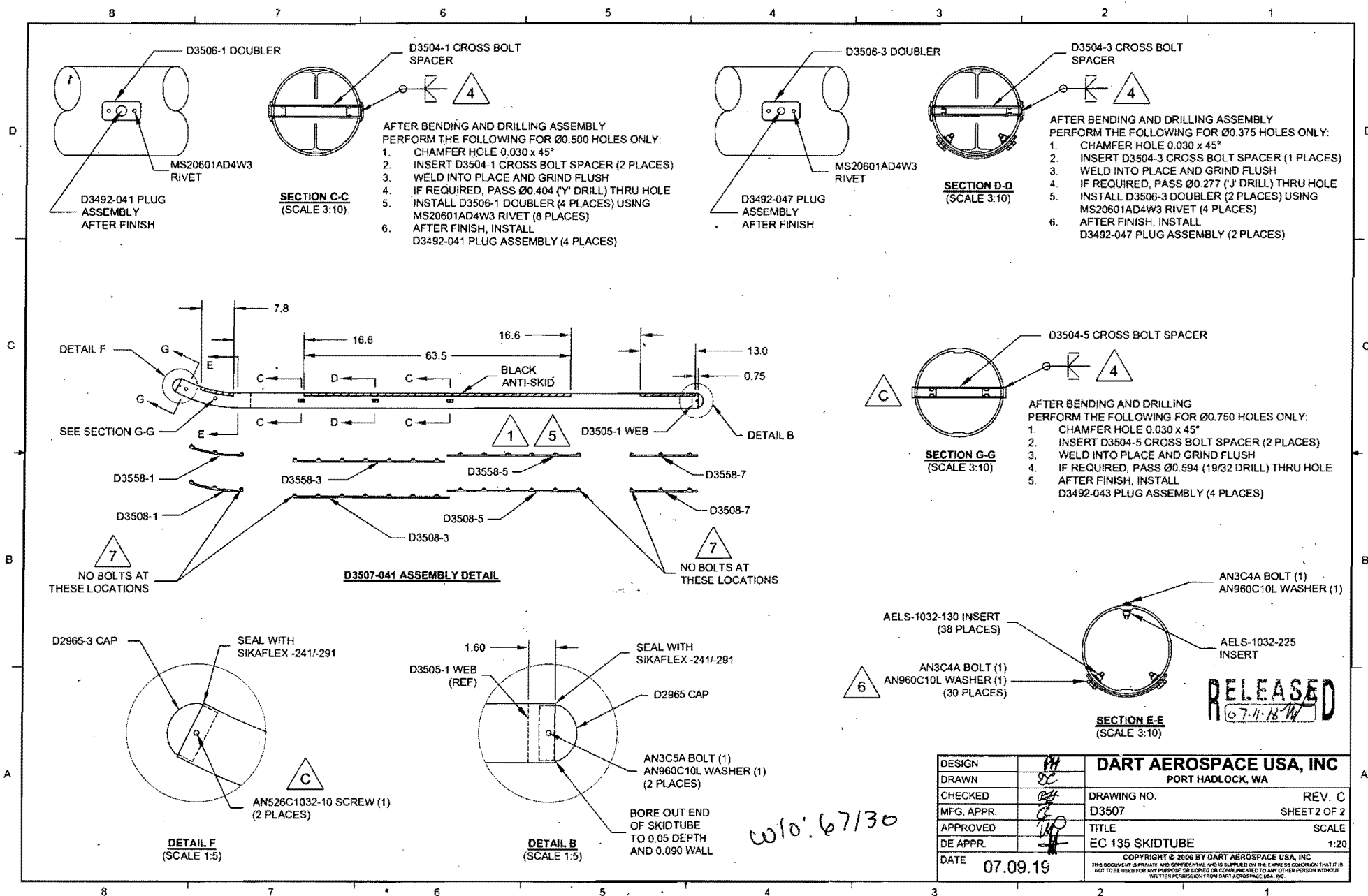
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	JTC	PORT HADLOCK, WA	
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	BA	D3507	SHEET 1 OF 2
APPROVED	BA	TITLE	SCALE
DE APPR.	BA	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	



DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

C211103109
W10.67130

RELEASED
07.11.16



NO. 247

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 66661
Part number: D135-751-011
Description: 135 skid truck
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[] fail[]

Qualifier Pat Jones Date of Test Coupon 11/03/17
Welder Barclay Elliot Date of Test Coupon 11/03/17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld